

Date: Wednesday, 3/15/2006 3:42:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW INSTALLATION
Job Number	: 26250		
Estimate Number	: 10044		
P.O. Number	: N/A	Part Number	: D044662011
This Issue	: 3/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3075 REV A2
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26051	Drawing Revision	: A2
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/22/2006
Checked & Approved By	: <u>06.03.16</u>	Qty:	10
Comment	: Est Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	26250A	R44 BEARPAW
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Comment: Sub-Component R44 BEARPAW

2.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-662-011 CHG002

DH 06/03/23

3.0	D2182B028	Rubber Clamp
-----	-----------	--------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B028 Rubber Cushion B24870

1 Paperwork package

4.0	D2274	Radius Block
-----	-------	--------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block B25769

5.0	D2529	Washer
-----	-------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer B25372

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/15/2006 3:42:08 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 26250

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2882

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3075-1 Bearpaw(REF) B26250

4 D2882 Clamp B24505

7.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-14A Bolt M15072

8.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt M19085

9.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer M19085

10.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M19099

Ref/4/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 26250

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206/04/04

(10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-662-011

Location: _____

REV B 206/04/04

(10)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206/04/05 (10)

Job Completion



u 206.04.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

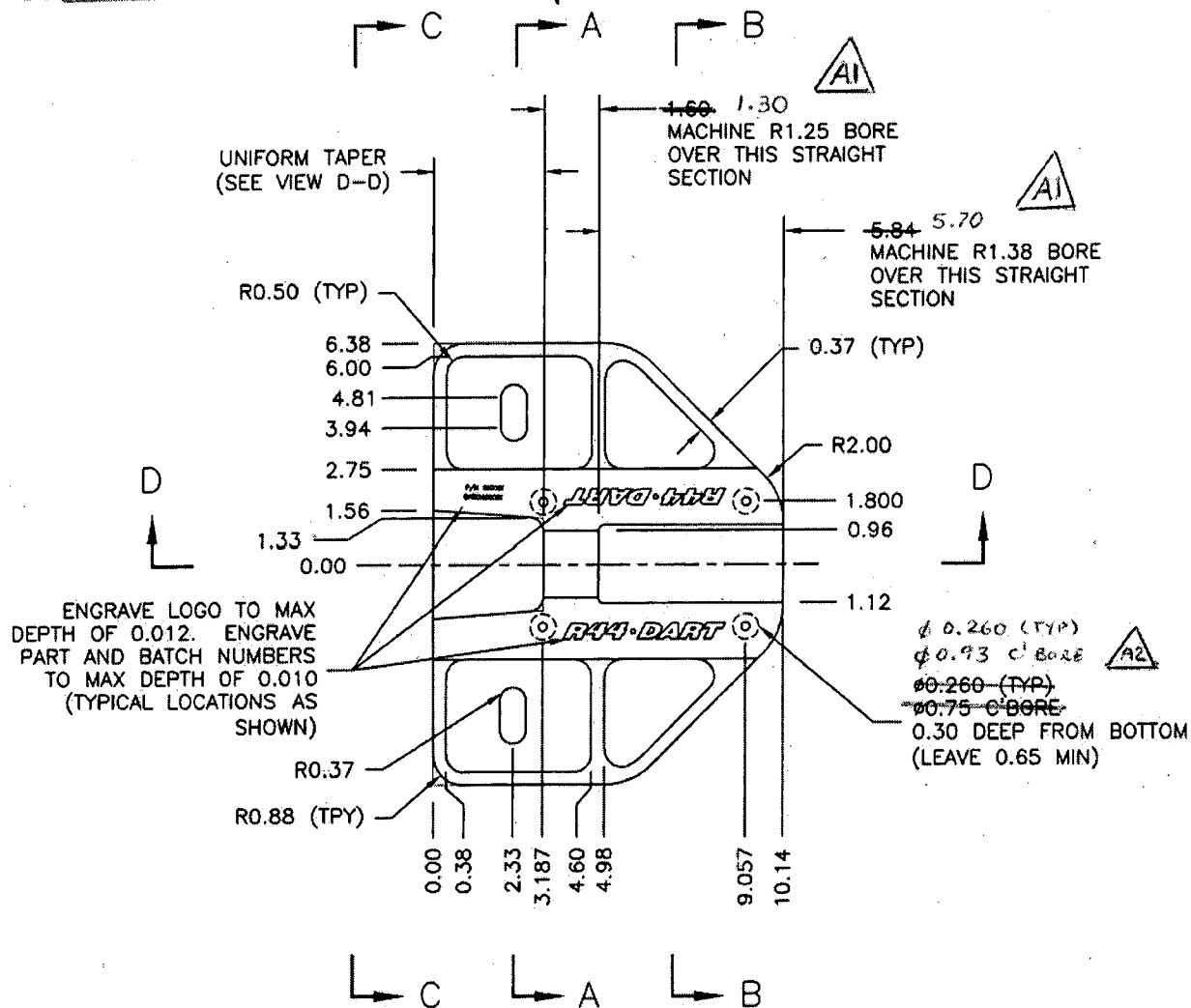
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3075 REV. A SHEET 1 OF 2	
DATE 02.01.04			TITLE R44 BEARPAW SCALE 1:5		
A	02.01.04		NEW ISSUE		
A1	RF 02.02.01		1.30 WAS 1.60 ; 5.70 WAS 5.84		
A2	RF 03.01.06		ø 0.93 WAS ø 0.75		

RELEASED
02-01-10



D3075-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

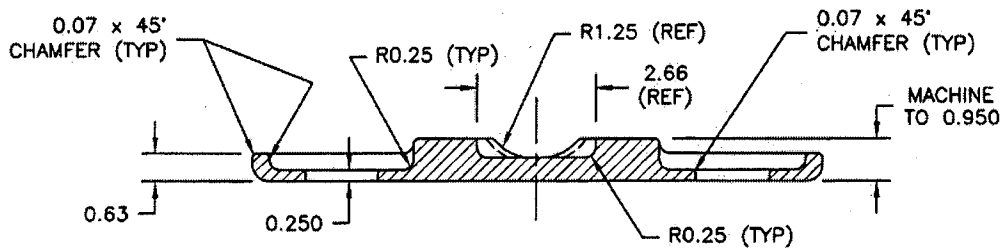
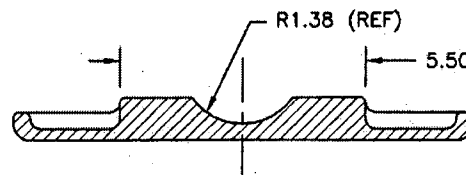
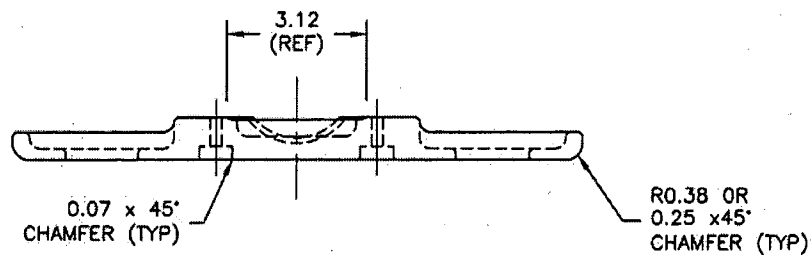
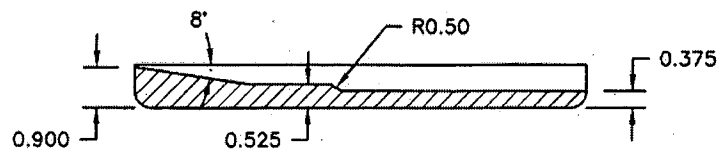
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3075	REV. A SHEET 2 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
02-01-10 [Signature]**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/15/2006 3:42:11 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R44 BEARPAW
Job Number	: 26250A		
Estimate Number	: 10100		
P.O. Number	: N/A	Part Number	: D30751
This Issue	: 3/15/2006 S.O. No. : N/A	Drawing Number	: D3075 REV A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A2
Previous Run	: 26051A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/22/2006
Checked & Approved By	: JF 06.03.16	Qty:	20 / 10 Um: Each
Comment	: Est Rev: C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 1.8949 sf(s)/Unit Total : 18.9490 sf(s)

Pick:

blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12

Material: Black UHMW 1"(MUHMWB10)

Batch: M106417

JF

06/03/29

10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1

3-Deburr

JF 06/03/29

JF 06/03/30

10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/03/30

10

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 06.03.30

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/15/2006 3:42:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 26250A

Part Number: D30751

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C206104104

(20)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26250A
Description: R44 Bearpaw		Part Number:	D3075-1
Inspection Dwg: D3075 Rev: A2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

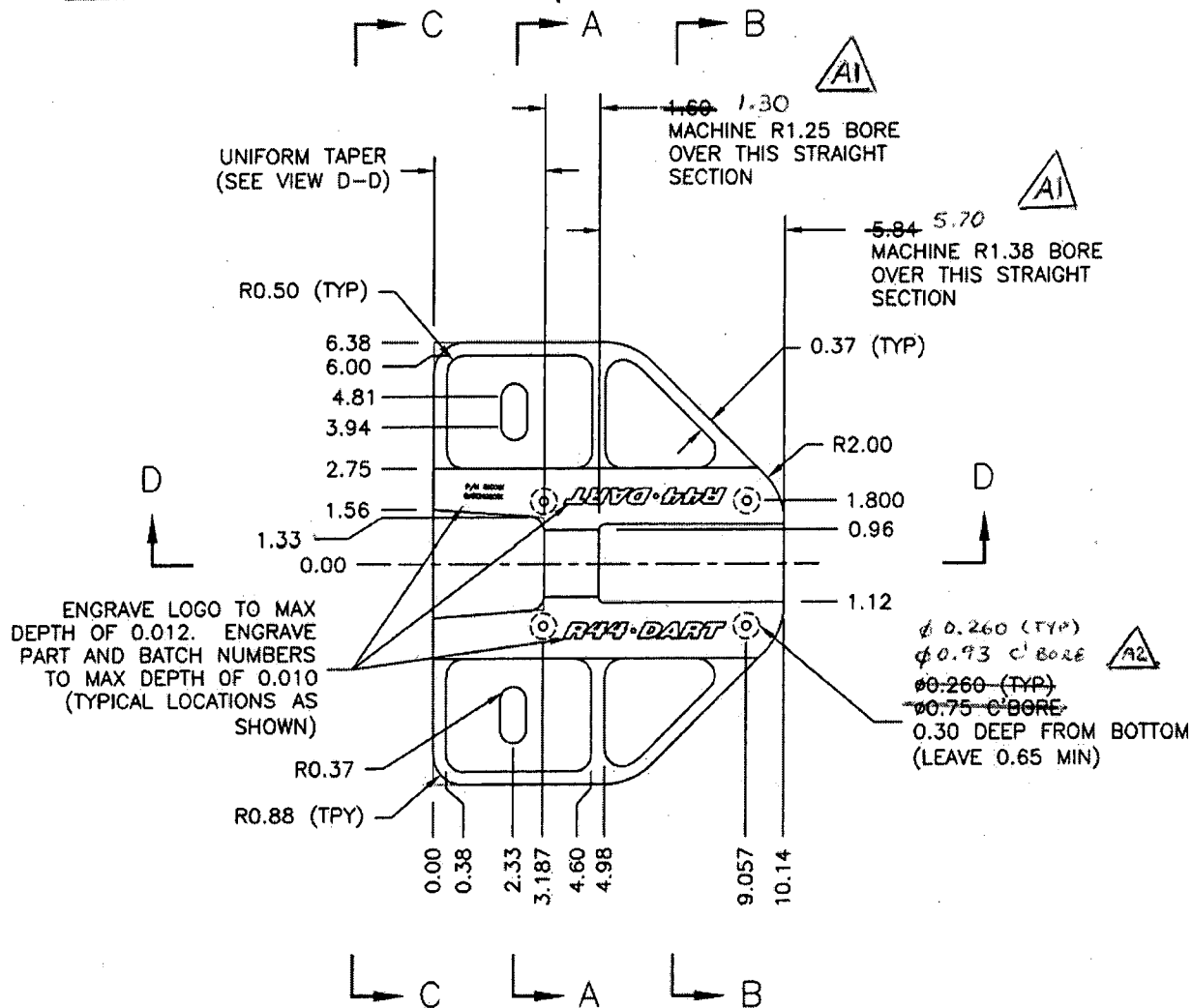
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	0.060x45°	—			
B	0.63	+/-0.030	0.620	—			
C	0.250	+/-0.010	0.245	—			
D	0.950	+0.030/-0.010	0.958	—			
E	5.50	+/-0.030	5.500	—			
F	0.25 x 45°	+/-0.030	0.255x45°	—			
G	0.900	+/-0.010	0.899	✓			
H	0.375	+/-0.010	0.378	—			
I	1.30	+/-0.030	1.295	—			
J	5.70	+/-0.030	5.700	—			
K	0.37	+/-0.030	0.380	✓			
L	3.600	+/-0.010	3.600	✓			
M	0.260	+0.005/-0.000	0.260	✓			
N	0.93	+/-0.030	0.929	—			
O	0.30	+0.030/-0.000	0.315	✓			
P	1.08	+/-0.030	1.080	—			
Q	5.870	+/-0.010	5.870	—			
R	10.14	+/-0.030	10.140	—			

Measured by:	<i>ML</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	06/03/29	Date:	06.03.29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF <i>RF</i>	<i>RF</i>

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3075	REV. A SHEET 1 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:5
A	02.01.04	NEW ISSUE	
A1	RF 02.02.01	1.30 WAS 1.60 ; 5.70 WAS 5.84	
A2	RF 03.01.06	φ 0.93 WAS φ 0.75	

RELEASED
02.01.10 *[Signature]*

D3075-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

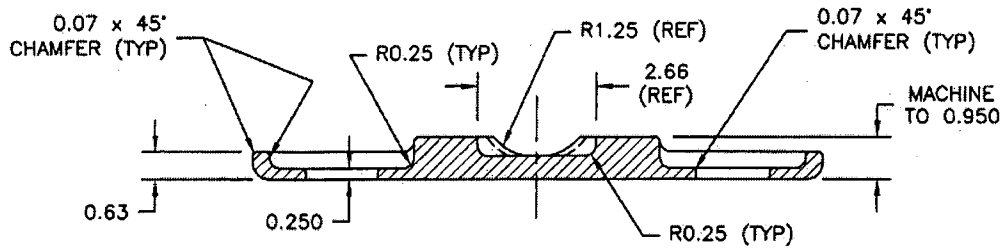
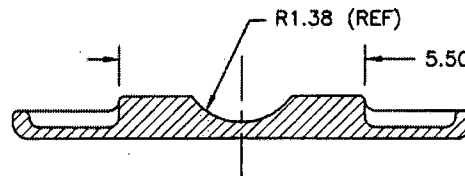
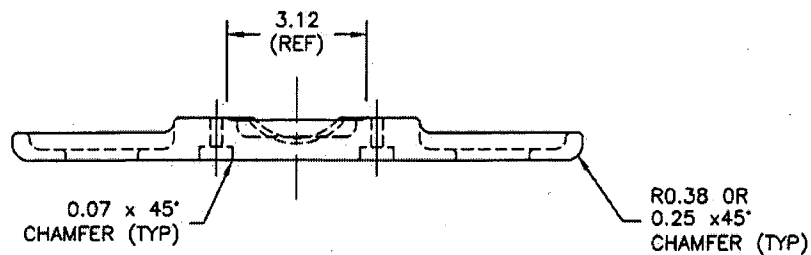
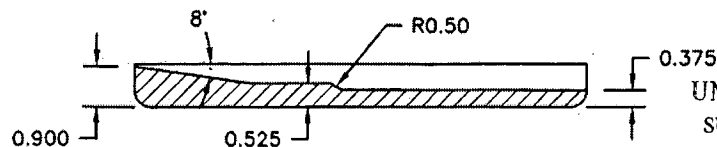
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN [Signature]	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3075	REV. A SHEET 2 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
02.01.10 [Signature]**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

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